

Date: Tuesday, 15/08/2006 7:17:37 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET ASSEMBLY
Job Number	28161	Part Number	D2804044
Estimate Number	11038	Drawing Number	D2804 REV B
P.O. Number	N/A	Project Number	N/A
This Issue	15/08/2006	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	B
First Issue	N/A	Material	N/A
Previous Run	25711	Due Date	08/09/2006
Written By		Qty:	8
Checked & Approved By		Um:	Each
Comment	Est D 05.03.30 MS21043-3 was MS21042L3	KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D28042	STA 155 Bracket			
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 8.0000 Each(s)			
	STA 155 Bracket				
Pick:					
Qty	Part Number	Description	Batch		
1	D2804-2	Bracket	<i>B26645</i> ✓		
2.0	D28054	Stop			
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 8.0000 Each(s)			
	Stop				
Pick:					
Qty	Part Number	Description	Batch		
1	D2805-4	Stop	<i>21306</i>		
3.0	D2809	Bushing			
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 8.0000 Each(s)			
	Bushing				
Pick:					
Qty	Part Number	Description	Batch		
	D2809	Bushing	<i>27617</i> ✓		
SMALL & MEDIUM FAB RESOURCE 1					
LARGE FAB RESOURCE 1					
To arm as per Dwg D2804					
SB		06/09/06			
H-100MISQULITY ASSURANCE APPROVED DAWNCRWD HED					
NOTE: Date & Initials of Initial Quality Assurance Approved DAWNCRWD HED					

W/O:

WORK ORDER CHANGES



WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Fault Category: _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

NCR: Yes No **DQA:** **Date:**

QA: N/C Closed: _____ Date: _____

Date: _____

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Drawing Name: BRACKET ASSEMBLY

Job Number: 28161

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Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP <i>106-09-06</i> (8)
Comment: INSPECT WORK TO CURRENT STEP		
6.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 a.m. 06-09-12 (1)		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION FC 06 09 12		
8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2809 into arm as per Dwg D2804 MF. 06/09/12. (8)		
9.0	AN3C16A	Bolt
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Bolt Pick: Qty Part Number Description Batch 2 AN3C16A Bolt 101189 ✓ AR 06/08/31		
10.0	MS210433	Nut
Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s) Nut Pick: Qty Part Number Description Batch 2 MS21043-3 Nut 10099 10mly AR 06/08/31		
11.0	NAS1515H3	Washer
Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s) Washer Pick: Qty Part Number Description Batch 2 NAS1515H3 Washer 14/9/05 (1) 100993 06/08/31 (1)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :	
	A/R LPS-3	Corrosion Spray	M17395 MF. 06/09/12 (8)
12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.</p>		
13.0	QC5	INSPECT WORK TO CURRENT STEP	SB 06/09/13 (8)
14.0	PACKAGING 1	PACKAGING RESOURCE #1	RB 06/09/14 (5) MF. 06/09/13
15.0	DC	DOCUMENT CONTROL	D 06/09/15 (8)
	<p>Comment: DOCUMENT CONTROL Inspection Level 21</p>		

Job Completion



W 06/09/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

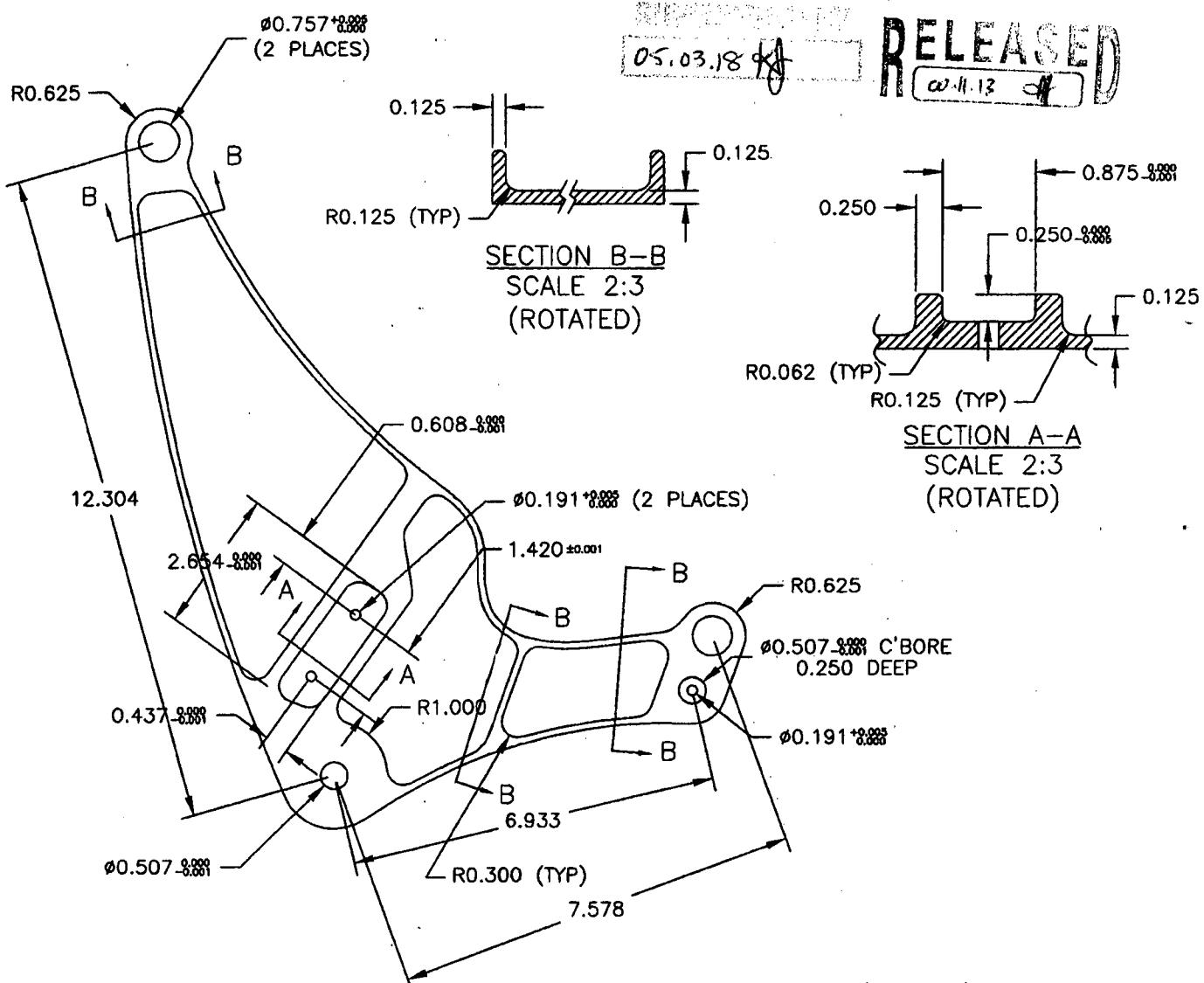
DART

COPY ISSUE

DESIGN	DRAWN BY
CHECKED	APPROVED
DATE	DRAWING NO.
00.11.07	D2804
	REV. A
	SHEET 1 OF 2

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DATE	TITLE	SCALE
00.11.07	STA 155 BRACKET	1:3
A	00.11.07	NEW ISSUE
A1	01.03.14	APP D2804-043/-044 <i>IP</i>

05.03.18 *IP*RELEASED *04.11.13*

MACHINE PER DRAWING FILE "D2804-A1.DWG"

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK

DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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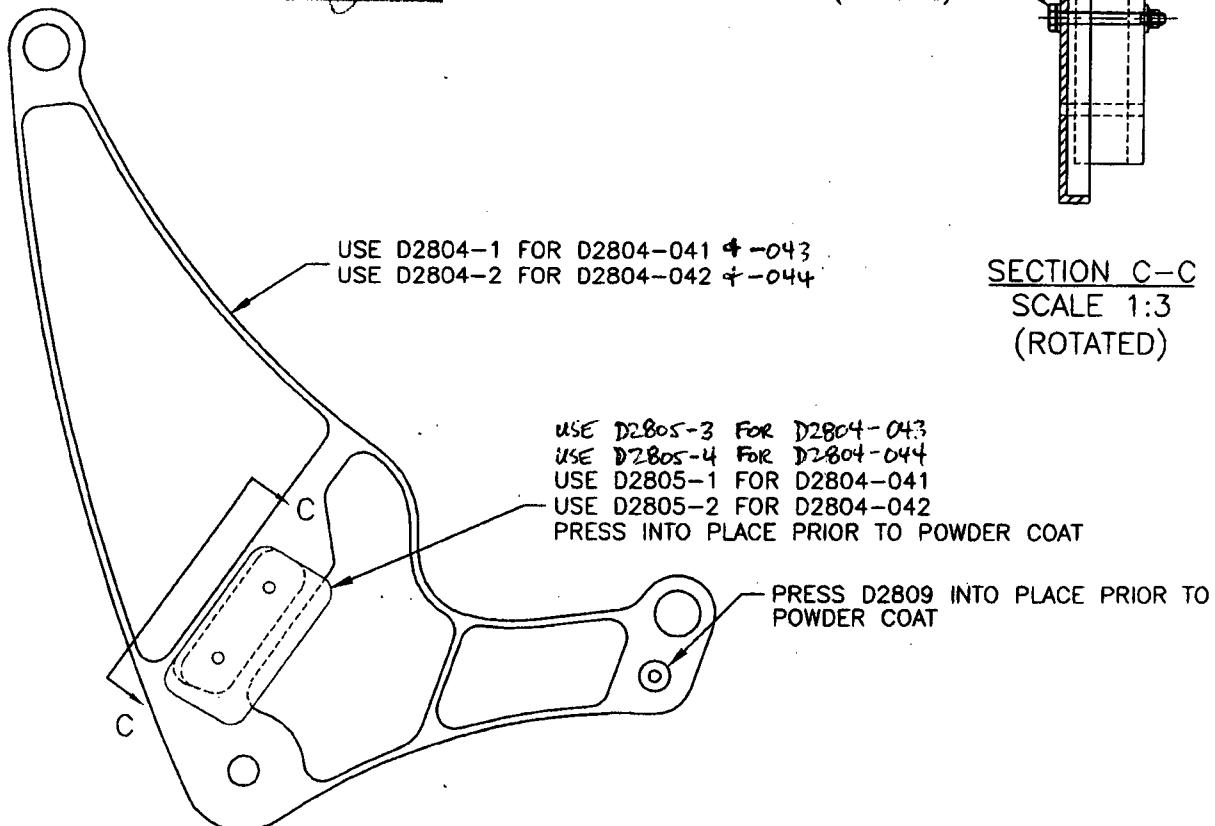
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	00.11.07	TITLE	SHEET 2 OF 2 1:3

RELEASED
00-11-13**SUPERCEDED BY**

05.03.18



D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR A1

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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